



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D5634-041BENT
Job Sheet 199962



Part No: D5634-041BENT

Job Qty: 1 pcs

Part Name: Float Skidtube Assembly, Bent



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/5/19

Job Tracking No:

Due Date: 9/19/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D5634 REV.A IPP REV:A 19.01.17 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - Bend - 1	1 pcs	9/19/19	9/19/19	0.50	0.22	Skidtubes - Bend		<i>M/L</i>
120	QC 5	1 pcs	9/19/19	9/19/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		<i>BE</i>
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
130	Packaging 3-1 - Stock - B4B	1 pcs	9/19/19	9/19/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		
							Packaging 3 - 11 - B4B		



Container No: S212365



Part: D5634-041BENT

Job No: 199962

Serial No/Batch: S212365

Revision: A

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
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Hawkesbury, ON K6A 1K7
CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

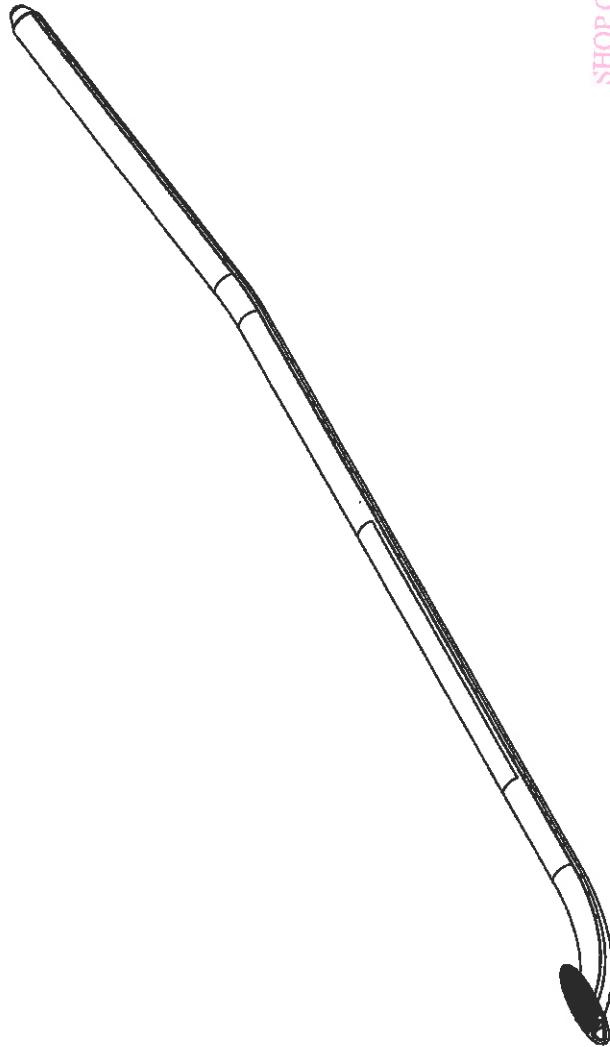
Date: 08/10/19

Plex 9/5/19 10:13 AM Dart.lajeunesse.marie

					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	BE
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	DAG
140	QC 21 - SA	1 pcs	9/19/19	0.00 0.00	QC 21 - SA - 21	21 SEP 12 2019
					QC 21 - SA - 70	9-89
Part Op 110 - ****VERIFY AND INSPECT THE MATERIAL PRIOR TO USE**** 1- Bend FWD end of tube using bend prog D5634 Descriptions: FWD and folio <u>BE</u> as per dwg D5634, cut fwd end of tube with saw table setup D5634 . 2- Test fit FWD cap. 120 - (QC5- Inspect part completeness to step on W/O) 130 - (Identify as per dwg & Stock Location: <u>LG002</u>) LOCAITON : LG002 140 - (QC21- Final Inspection - Work Order Release)						
Job BOM						
Part / Item	Component Name	Quantity	Operation	Container		
D2600-1-190	Extrusion Round 3" 206	1 pcs (1 ea)	110-Skidtubes - Bend - 1	(2) 15108/169		
Job Allocations						
Operation	Component Part	Required	Inventory	Allocated		
110-Skidtubes - Bend - 1	D2600-1-190	1	25	0		
Part Specifications						
Specifications could not be found.						

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QTY	PART NUMBER	DESCRIPTION
X	D5634-041	FLOAT SKIDTUBE ASSEMBLY
1	D2846	AFT CAP
7	D3275-1	SPACER
23	D4720-1	SPACER
1	D5633-1	TOW STEP
1	D5634-1	FLOAT SKIDTUBE
1	D5636-041	FLOAT WEB ASSEMBLY
2	M824693-C272	SCREW, CSK 100°



D5634-041 FLOAT SKIDTUBE ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: PRIME PER DART QSI 005 4.1 (FLOAT SKIDTUBE PRIMER)
PAINT GLOSS BLACK PER DART QSI 005 4.2.2.4 (FLOAT SKIDTUBE PAINT)
BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.4 ON INNER TUBE SURFACE AT AFT END.
- 7) WEIGHT: 21.03 lb
- 8) SEALING SURFACES WITH SIKAFLEX -241/281 OR PROSEAL P/S 8801/422 OR MIL-S-8802 CLASS B2 SEALANT
- 9) INSTALL FASTENERS WELT WITH SIKAFLEX -241/281 OR PROSEAL P/S 8801/422 OR MIL-S-8802 CLASS B2 SEALANT
- 10) INSULATE INSIDE OF OUTER TUBE WITH SIKAFLEX -241/281 ADHESIVE PER DART QSI 015.
- 11) DAMAGE TOLERANCE: NO BENDS
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5" ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020" DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 12) WELDING PER QSI 015
- 13) IT IS PERMISSIBLE TO GRIND SKIDTUBE TO IMPROVE FIT WITH TOW STEP. DIMENSIONS SHOWN AFTER GRINDING FOR TOW STEP.
- 14) SLOT FOR D5633-1 TOW STEP THRU BACK WALL ONLY.

RELEASED

2018 JUN 27
EAL H-74

APPROVED

SHOP COPY

UNCONTROLLED COPY

SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

NO. 199962 M15

19-09-05

REV.	NEW ISSUE	DESCRIPTION	ZF	BY	DATE
DESIGN			ZF		
DRAWN			ZF		
CHECKED			MW		
MFG. APPL.			DD		
APPROVED			NO		
DE APPR.			CP		
DATE	18.04.24				

DART AEROSPACE LTD

HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

D5634

REV. A

SHEET 1 OF 4

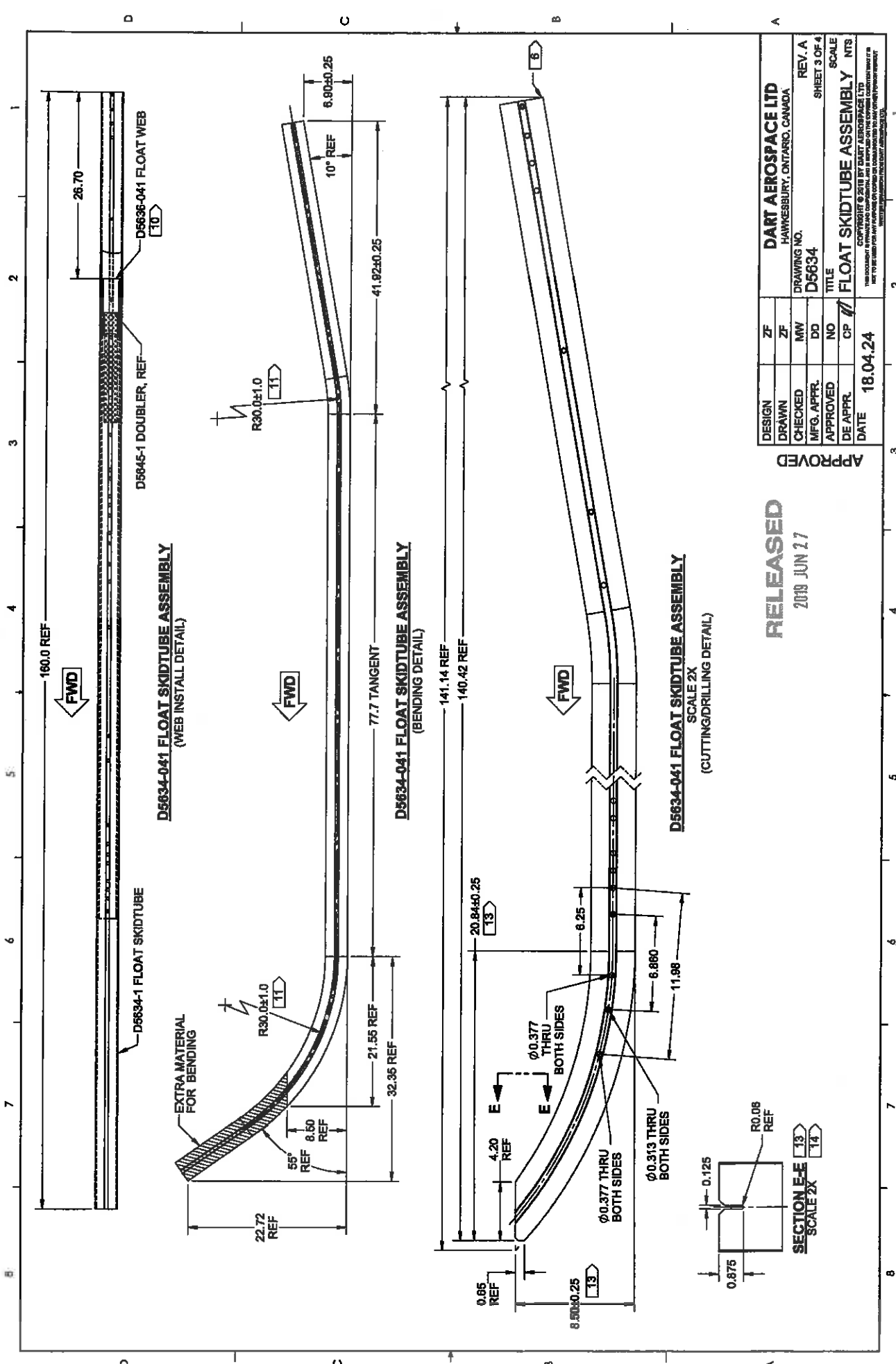
SCALE

NTS

FLOAT SKIDTUBE ASSEMBLY

18.04.24

DATE



RELEASED
2019 JUN 27

DESIGN	ZF	DART AEROSPACE LTD
DRAWN	ZF	HAWKESBURY, ONTARIO, CANADA
CHECKED	MW	DRAWING NO.
MFG. APPR.	DO	D5634
APPROVED	NO	TITLE
DE APPR.	OP	FLOAT SKIDTUBE ASSEMBLY
DATE	18.04.24	SCALE
		NTS

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ ☐ ☐ Scrap ☐ ☐ ☐ Use-as-is ☐ ☐ ☐			DEPARTMENT/PROCESS Skid-tube ☐ ☐ ☐ ☐ ☐ Machining ☐ ☐ ☐ ☐ ☐ Large Fab ☐ ☐ ☐ ☐ ☐ Cross tube ☐ ☐ ☐ ☐ ☐ Small Fab ☐ ☐ ☐ ☐ ☐ Finishing ☐ ☐ ☐ ☐ ☐ Eng. (Non-AW) ☐ ☐ ☐ ☐ ☐ Prod. Eng. Coord. ☐ ☐ ☐ ☐ ☐ Rec/Store/Packaging ☐ ☐ ☐ ☐ ☐ Engineering ☐ ☐ ☐ ☐ ☐ Water Jet ☐ ☐ ☐ ☐ ☐ Supplier ☐ ☐ ☐ ☐ ☐ Quality ☐ ☐ ☐ ☐ ☐			Date: _____ Sequence #: _____		QTY Affected: _____		MRB (QS1042) _____																																																																					
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